

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services		<b>Drawing Name</b>	: FLOOR PROTCTOR FWD LH		
<b>Job Number</b>	: 39159					
<b>Estimate Number</b>	: 11227					
<b>P.O. Number</b>	:		<b>Part Number</b>	: D32811		
<b>This Issue</b>	09/05/2008	<b>S.O. No.</b>	<b>Drawing Number</b>	: D3281 REV D		
<b>Prsht Rev.</b>	: NC		<b>Project Number</b>	: N/A		
<b>First Issue</b>	: / /		<b>Drawing Revision</b>	: D		
<b>Previous Run</b>	: 38018		<b>Material</b>	:		
<b>Written By</b>	:		<b>Due Date</b>	16/05/2008	<b>Qty:</b>	10
<b>Checked &amp; Approved By</b>	: JLD 08.5.09		<b>Um:</b>	Each		
<b>Comment</b>	: Est Rev:A 04.07.01 New issue KJ/JLM Est. Rev B. 07.16.2007 Thermoform in house DL Est Rev C. 08.02.06 To reflect updated Dwg. DL Est Rev. D 08.04.15 Material Change DL					

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description:</b>
1.0	MLEXS093F600602	GE PLASTICS LEXAN SHEET
<b>Comment:</b> Qty.: 4.3330 sf(s)/Unit Total: 43.3300 sf(s) GE PLASTICS LEXAN SHEET		
	Material Batch Number	M106 751
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
<b>Comment:</b> HAND FINISHING THERMOFORMING		
3.0	1) Cut Blanks	BB 08/05/15 X10
	THERMOFORMING	
<b>Comment:</b> THERMOFORMING MACHINE		
4.0	Thermoform as per Dwg. D32811 and Folio FTA 011	
	Dwg. Rev. B	
	Folio Rev. B	
		BB 08/05/15
QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3281-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 39159		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/21	2.0	Formation Factor, Trimming Error						
	5.0							
08/05/21	# 2.0	two parts scrap on thermoflame one - operator forgot to reset the machine temperature.	Initial Chief Eng	Scrap and Destroy, and Replace Qty 1/2 B# M106751	08/05/21	08/05/21	08/05/21	08/05/21
			Initial Chief Eng	ADD note in Folio to insure that the machine temperature is Reset.	08/05/21	08/05/21	08/05/21	08/05/21

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:45:34 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTCTOR FWD LH

Job Number: 39159

Part Number: D32811

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



(Ph) →

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/05/21 X 10

6.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

BB 08/05/21 X 10

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BB 08/05/22 X 10

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

8/13/22 SP 10x

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/23 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08/05/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3281-1 PAR #: N/A Fault Category: Prod / Thermforming NCR: Yes No DQA:  Date: 08/05/22  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 39159		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/22	5.0	two parts scrap Due to improper trimming. R.C. Parts heat up to the point of burning employees to hand. Solution is	<input checked="" type="checkbox"/> 08/05/22	Scrap and destroy and replace. Qty (x2) B# M106751	08/05/22 W.L.	<input checked="" type="checkbox"/> 08/05/22	<input checked="" type="checkbox"/> 08/05/22	<input checked="" type="checkbox"/> 08/05/22
			<input checked="" type="checkbox"/> 08/05/22	Solution is to use a Teflonine Delrin Block to hold down part while trimming / needs large trimming surface	08/05/22 W.L.	<input checked="" type="checkbox"/> 08/05/22	<input checked="" type="checkbox"/> 08/05/22	<input checked="" type="checkbox"/> 08/05/22

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39159
Description: Floor Protector, Fwd LH	Part Number:	D3281-1
Inspection Dwg: D3281 Rev: D		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875" Go/No Go	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/05/20

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.6	+/-0.100	18.62	✓			
17.1	+/-0.100	17.15	✓			
11.7	+/-0.100	11.65	✓			
0.95	+/-0.030	.978	✓			
0.25	+/-0.030	.265	✓			
0.030	Min	.49	✓			
0.070	+/-0.010	.86	✓			

Measured by: BB

Date: 08/05/20

Audited by: BB

Date: 08/05/20

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL <u>BB</u>	<u>BB</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

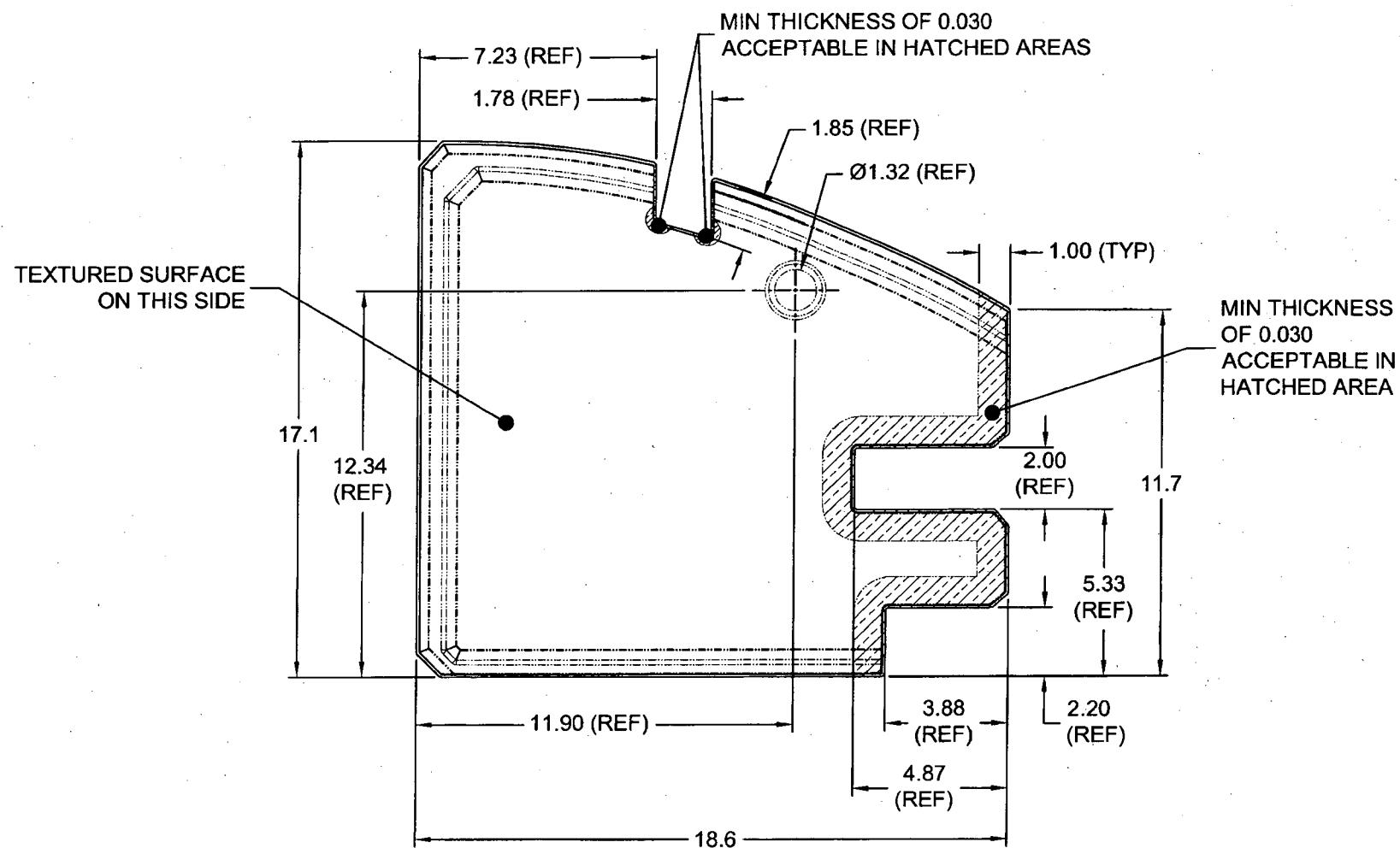
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
2.0								

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

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### D3281-1 FLOOR PROTECTOR

#### D3281-1 NOTES:

- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.95 lb

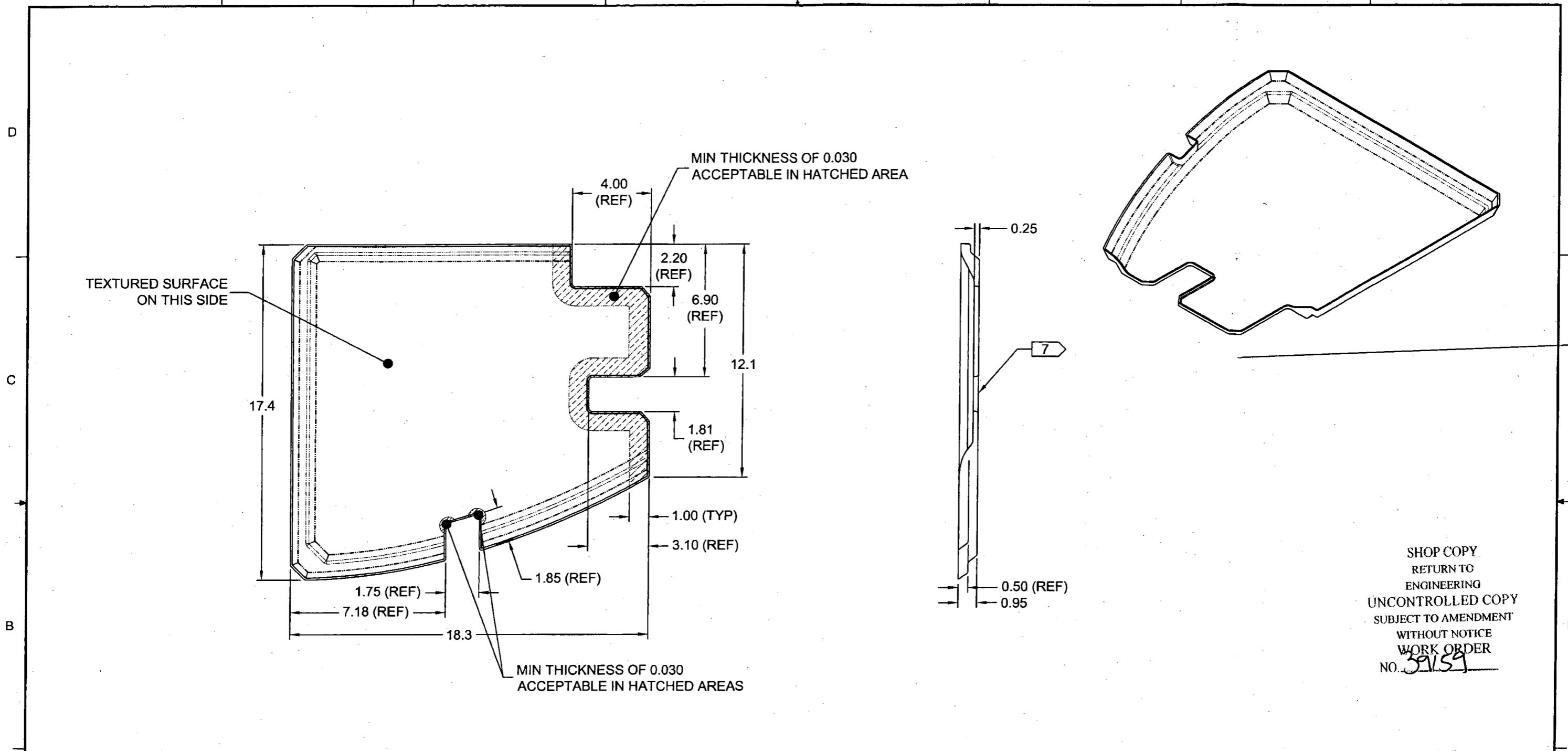


D	THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.080, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS: COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	90	DART AEROSPACE LTD	
DRAWN	84	HAWKESBURY, ONTARIO, CANADA	
CHECKED	13	DRAWING NO.	REV. D
MFG. APPR.	DJ	D3281	SHEET 1 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	CH	FLOOR PROTECTOR	NTS
DATE	08.03.28	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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05.04.11 WD

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8 7 6 5 4 3 2 1



### D3281-2 FLOOR PROTECTOR

#### D3281-2 NOTES:

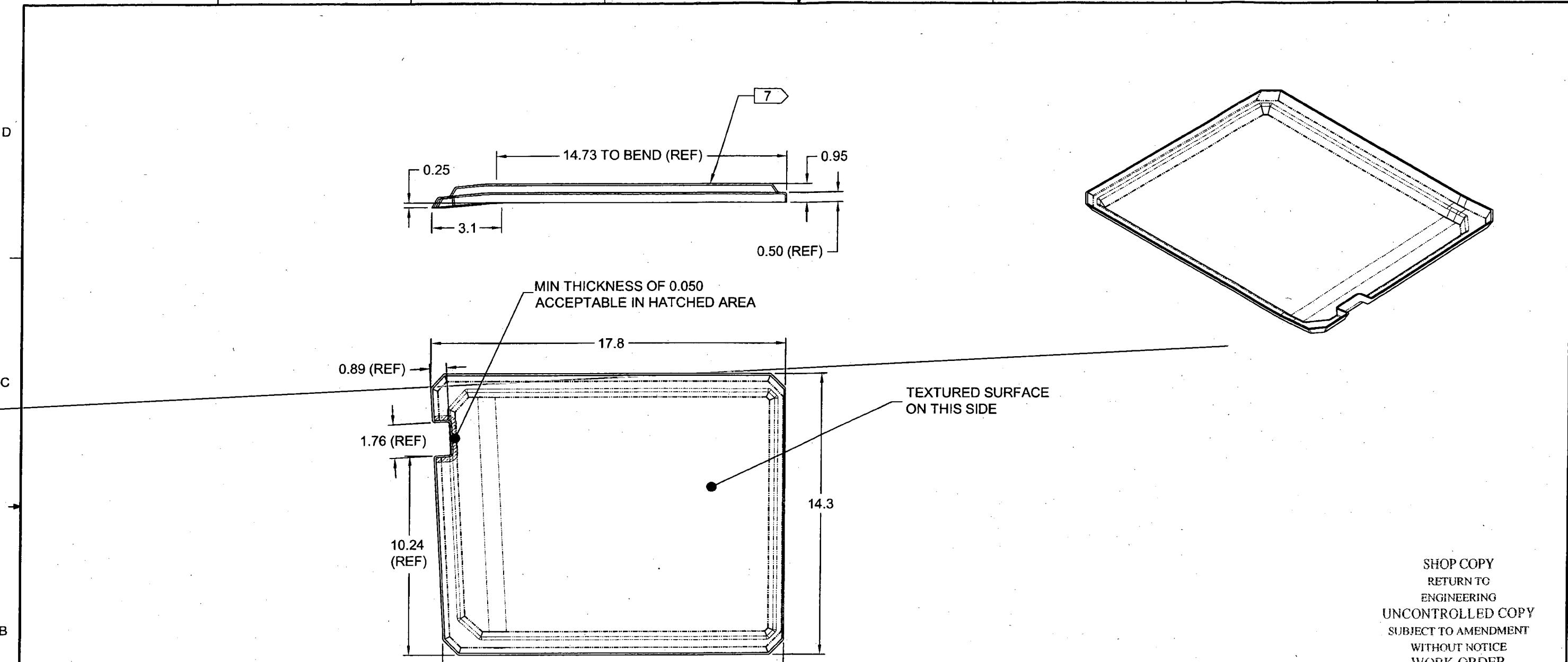
- 1) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.97 lb



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08/11/04

DESIGN	9P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	84	
CHECKED		DRAWING NO.
MFG. APPR.		REV. D
APPROVED		D3281
DE APPR.		SHEET 2 OF 4
DATE	08.03.28	TITLE
		SCALE
		FLOOR PROTECTOR
		NTS
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08-04-11 MHD

### D3281-3 FLOOR PROTECTOR

#### D3281-3 NOTES:

- 1) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb



DESIGN	<i>Q</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	<i>RF</i>	
CHECKED	<i>1</i>	DRAWING NO.
MFG. APPR.	<i>W/0</i>	D3281
APPROVED	<i>W/0</i>	REV. D
DE APPR.	<i>W/0</i>	SHEET 3 OF 4
DATE	08.03.28	SCALE
		FLOOR PROTECTOR
		NTS

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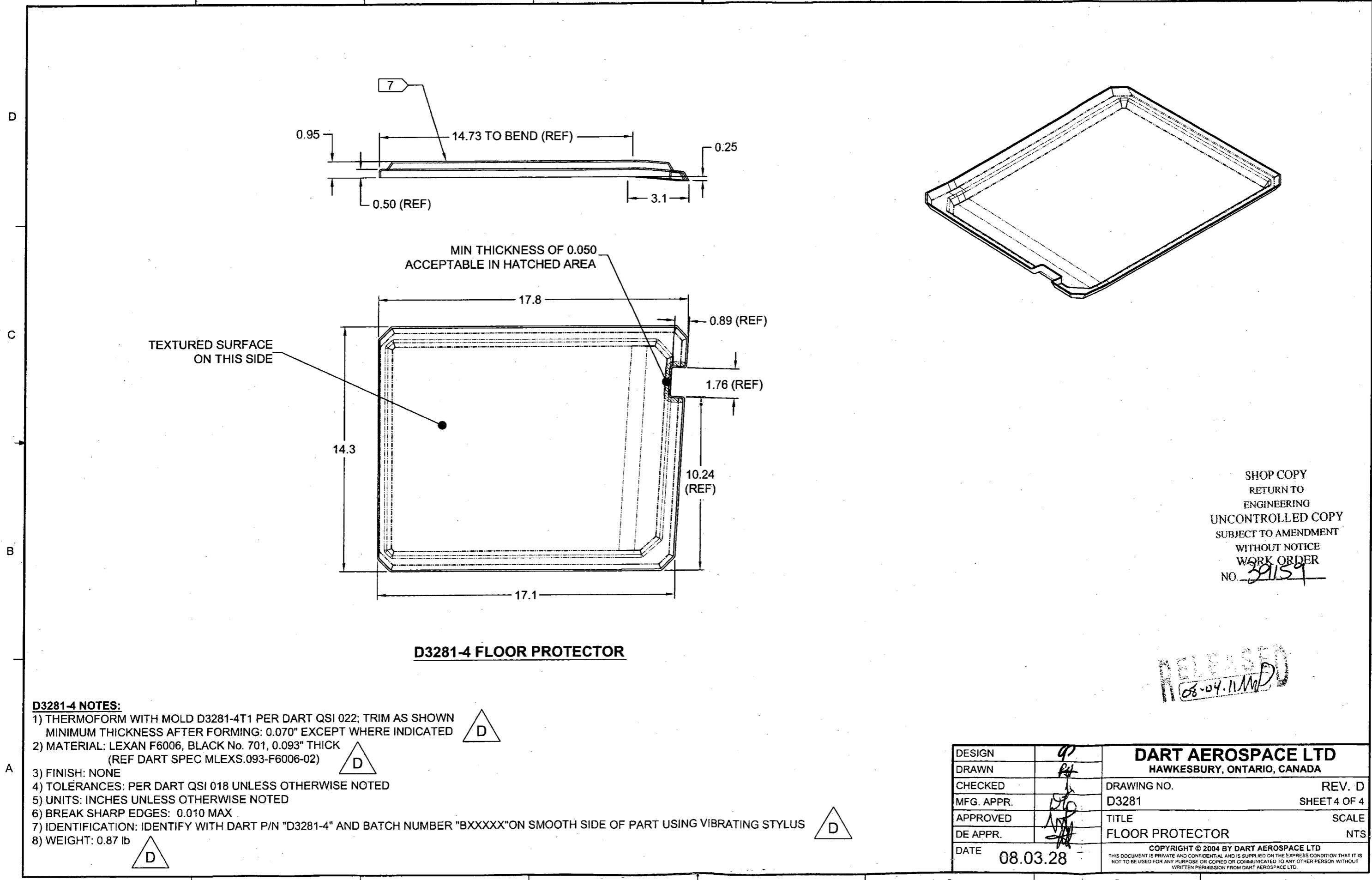
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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1